

Work Order ID 137189

137189

Page 1

Thursday, September 24, 2015 2:12:10 PM

Item ID: D3535-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Center
 Start Date: 9/23/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: SEP 23 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

OAS
38
9-89
OCT 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
Misidentified ☐	☐	Past Due ☐					

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Page 2

Thursday, September 24, 2015 2:12:10 PM

Item ID: D3535-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 9/23/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT83262- Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25	0.00 0.00				DAS 36 9-89	7		15/10/05 DAS 36 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(7)			DAS 38 9-89 OCT 05 2015
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M BofH6.</i> Memo START TIME: <u>8:40.</u> OVEN TEMPERATURE: <u>300°</u> FINISH TIME: <u>9:10.</u>	0.00 0.00				7	15-10-13		DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER : _____							

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Page 3

Thursday, September 24, 2015 2:12:10 PM

Item ID: D3535-25 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Center
Start Date: 9/23/15 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 9/23/15 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						(7)			
QC	Memo	0.00							
Quality Control									OCT 13 2015
170	Identify as per dwg & Stock Location: FP-002	0.00							
170						x7			
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

MCS OCT 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

Picklist Print

Thursday, September 24, 2015 2:12:09 PM

Page 1

Work Order ID: 137189

137189

Parent Item: D3535-25

D3535-25

Parent Item Name: Wearplate Center

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	346.8623	0.51	3.221053			

M304S20GA

304/316 .040 Sheet

09/15/15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	22.6	
m131700	22.6	
MAT020	324.2623	
m130345	1.3139	
m131060	90.2484	
<u>m132387</u>	232.7	
		<u>3.2</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 137189
Description: Wearshoe		Part Number: D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.891	/		V-Ducad	
1.937	+/-0.010	1.940	/		V-Ducad	
1.450	+/-0.010	1.453	/		Tape	
5.450	+/-0.010	5.452	/			
10.900	+/-0.010	10.900	/			
16.350	+/-0.010	16.350	/			
21.800	+/-0.010	21.800	/			
Ø0.188	+0.005/-0.001	Ø.189	/			
12.750	+/-0.010	12.750	/			
6.75	+/-0.030	6.75	/			
6.00	+/-0.030	6.00	/			
0.300	+/-0.010	0.303	/			
0.300	+/-0.010	0.302	/			
0.038	+/-0.010	0.036	/			

DAS

Measured by:	DL
Date:	15/10/01

Audited by:	38
Date:	15-10-01

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	



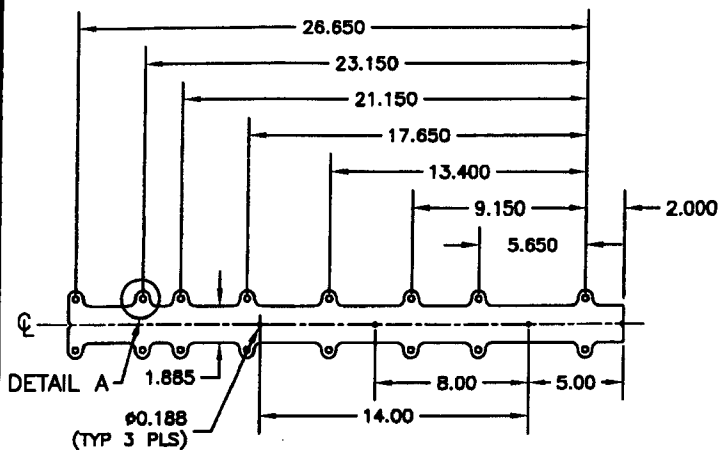
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07.04.24

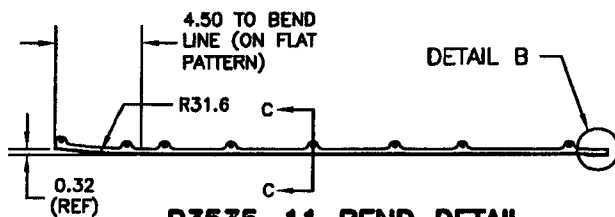
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137189 MLS

15-09-25

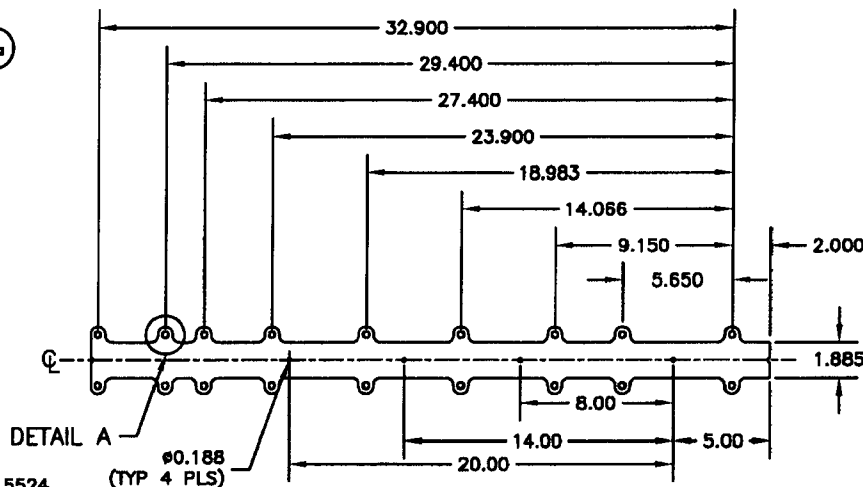
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE 1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC



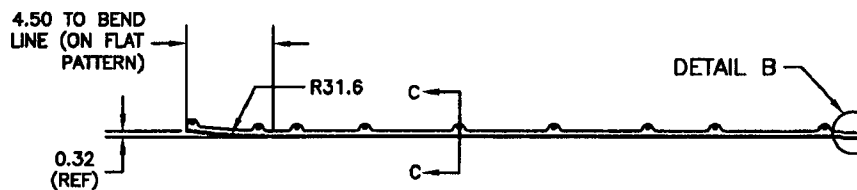
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

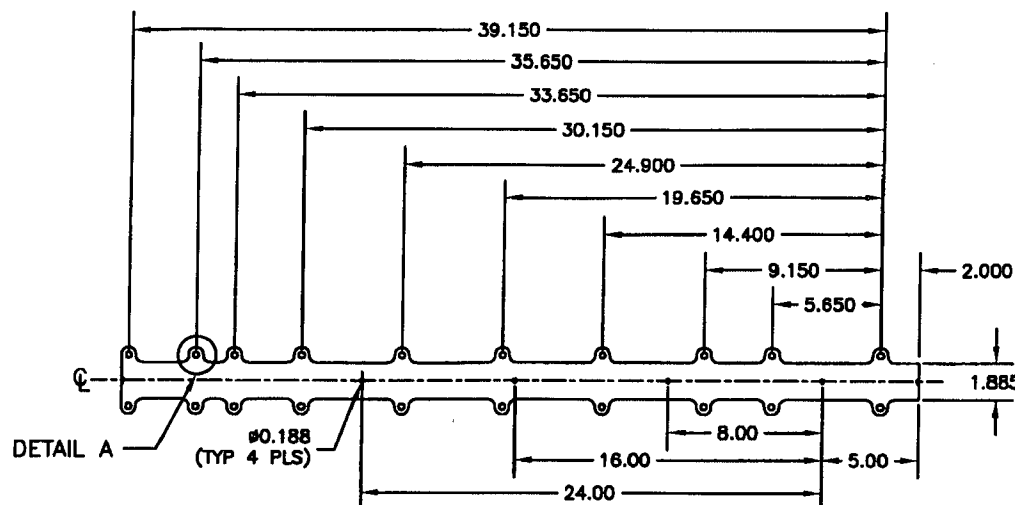
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



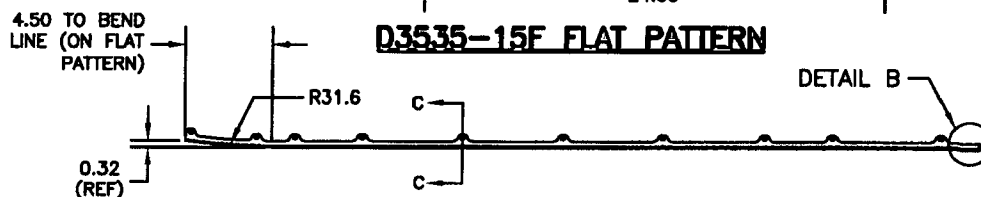
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07.04.24

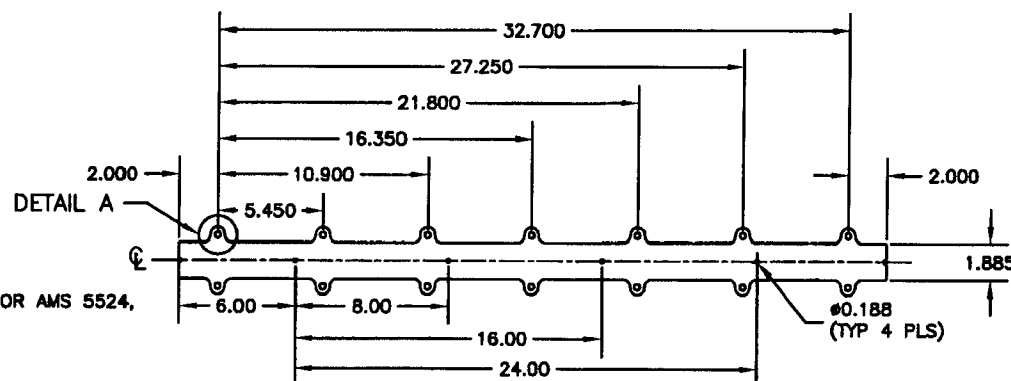
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 2 OF 7
07.04.17	WEARSHOE	SCALE 1:10



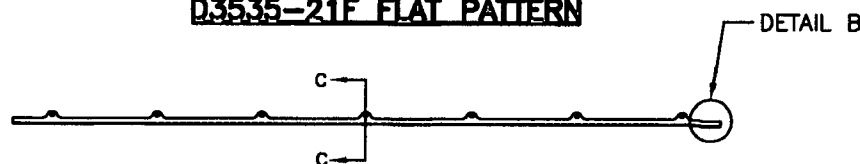
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

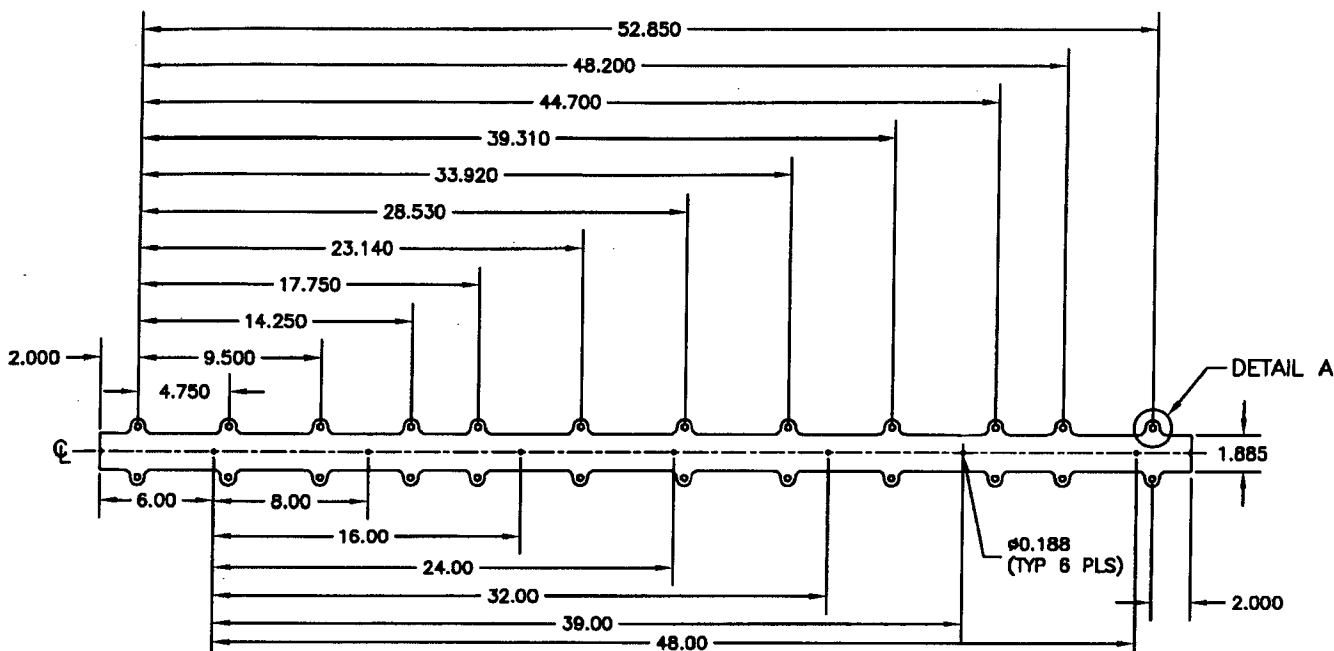
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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RELEASED

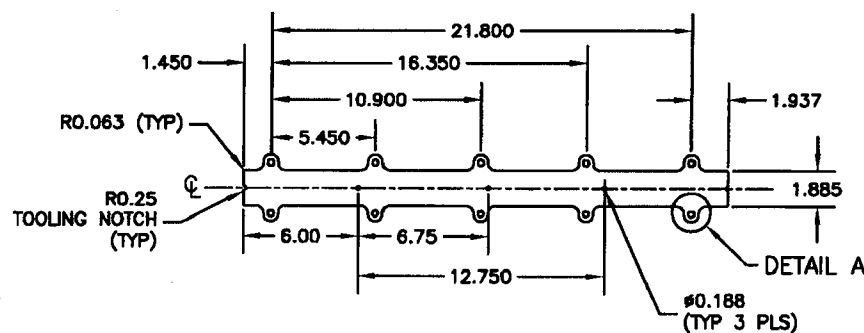
07 04 24



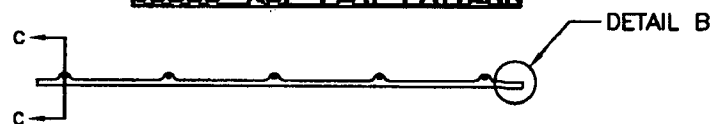
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

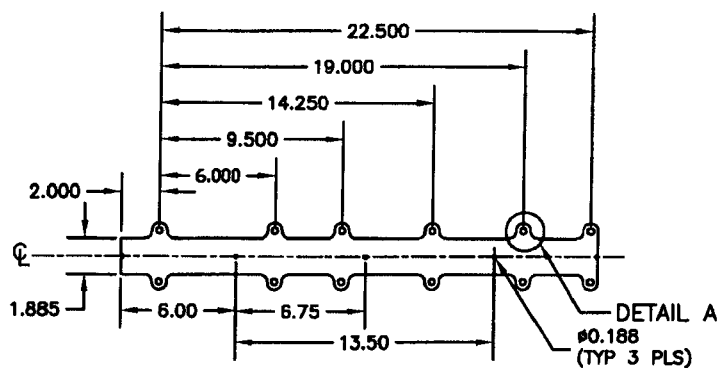
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 3 OF 7
		SCALE
		1:10



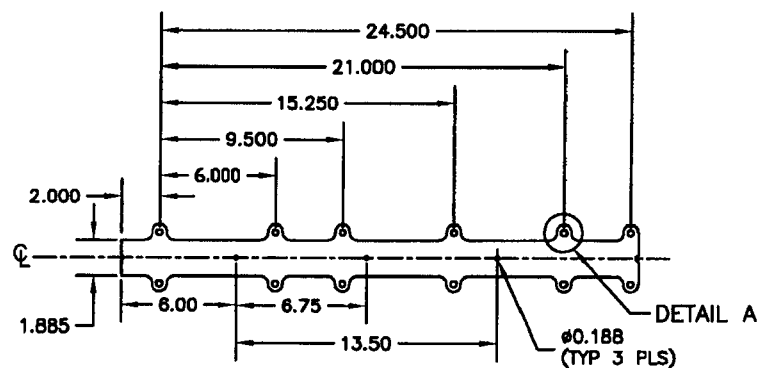
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07.04.24



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7	SCALE 1:10

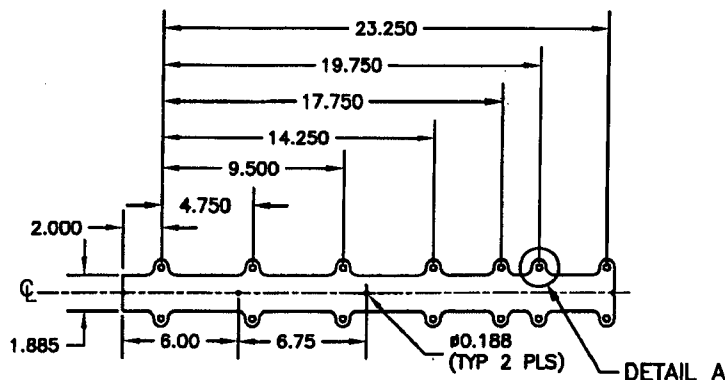
NOTES

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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
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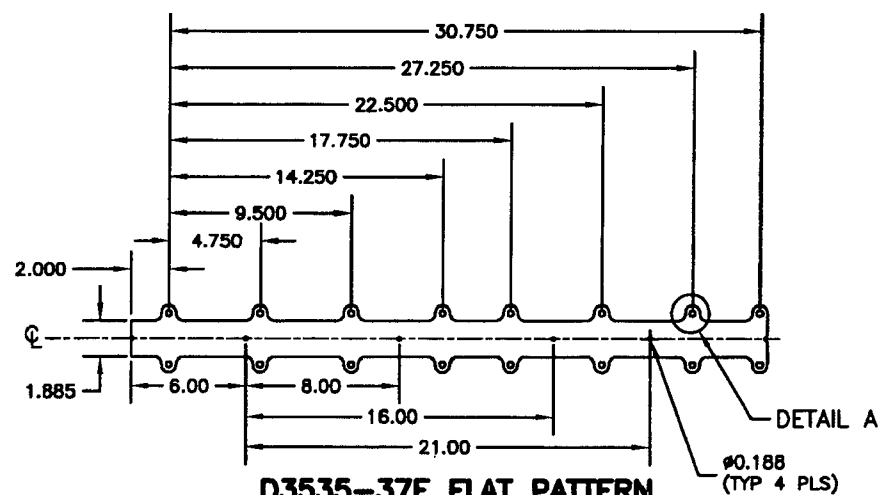
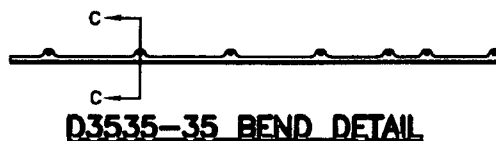


RELEASED
07.04.24

DESIGN	C B	DRAWN BY	CH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				SCALE
				1:10
				REV. B
				SHEET 5 OF 7



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



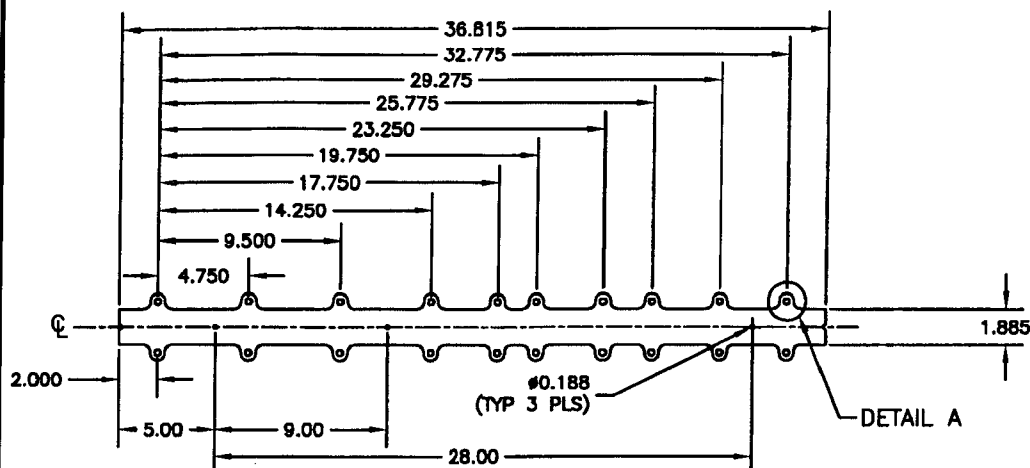
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

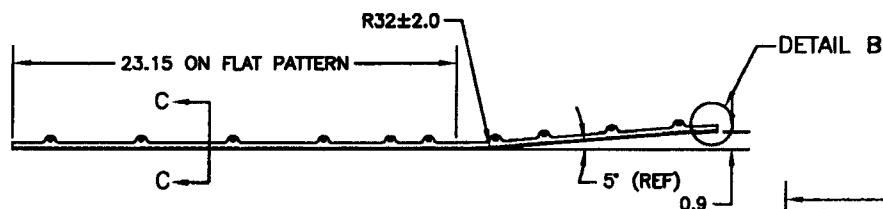


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07.04.17

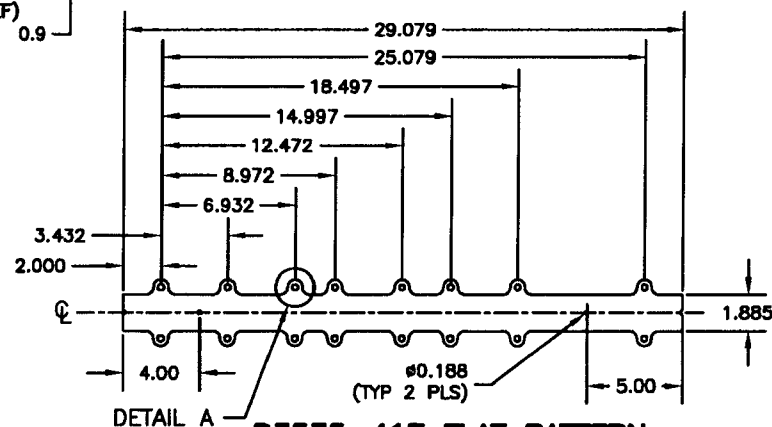
DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



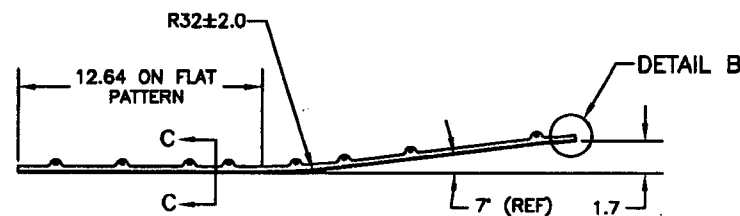
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

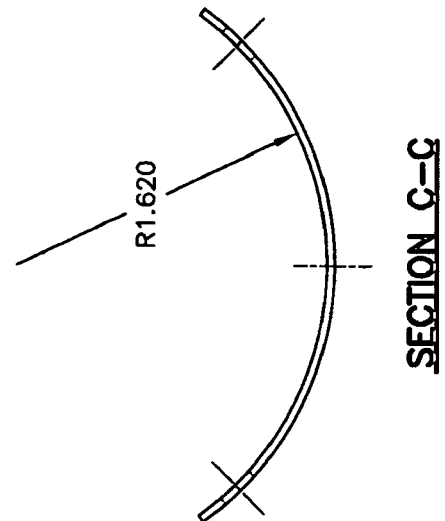
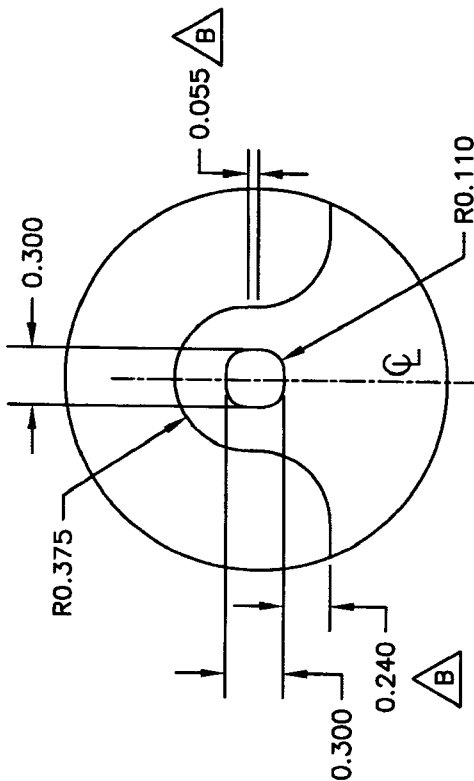
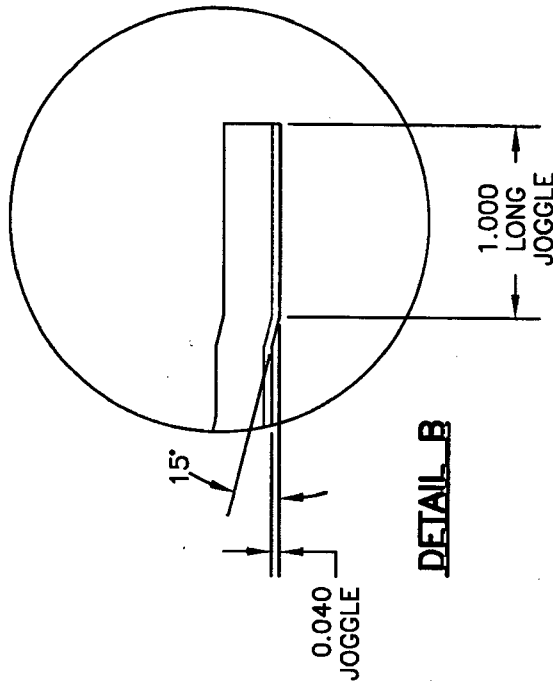
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24



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